QC2- Inspect parts off machine FAI/FAIB

Memo

110

QC

\*110\*

Quality Control

Jm 12-10-19

October-18-12 9:07:53 AM Item ID: D3929-041 Accept \*N900040100\* Setup Start **Revision ID:** Stop Gusset Assembly Item Name: \*4\* **Start Date:** 10/18/12 Start Qty: 4.00 **Cust Item ID:** Required Date: 11/02/12 Req'd Qty: 4.00 **Customer:** Reference: Run Date 2-10-18 Tooling: **Process Plan:** Date: **Approvals:** Stop Date: SPC (Y/N): QC: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID Description Run Hours** Code Qty **Qty** Number Stamp Draw Nbr **Revision Nbr** D3929 Rev A 100 0.00 \*100\* Jm12-10-19 0.00 Waterjet Memo FLOW CNC Waterjet 1-Cut as per Dwg D3929 Dwg Rev:\_\_\_\_\_ 304,125" Prog Rev: 2-Deburr if necessary

0.00

0.00

												DQA:	Date	e:	
NCR:	Yes /	No				WORK ORDER NON-C	O	NFORM	AANCE / UP	DATE		•			
						•						QA Closed:	Date	e:	
Work Orde	or:					DISPOSITION				AGAINST [	ÞΕΙ	PARTMENT	PROCESS		
WOIK OIG	ei				<u>.</u>	Rework	1		Skid-tube	Crosstube	7		Water Jet		Engineering
Part N	No					Scrap Use-as-is		ſ	Machining noforming	Small Fab Finishing			d. Eng. Coor. e/Packaging	$\exists$	Quality
NCR I	No					Work Order Update	]		Large Fab	Composite			Supplier		
Root					Descri	ption of work order update	T i	nitial	Act	ion		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	ription		Date	Verification		QC Inspector
Doc/Data															
Equip/Tooling															
Operator															
Material						X							:		
Setup		•						-							
Other							1								
Process									÷			:			
Supplier							1								
Training	П														
Unapproved	П														
						F	ΑUL	T CATE	GORY						
Landi	ing Ge	ar				General		_		_		_	_		
	В	ending				Bend		Grain		·		Ovalized			Pressure/Forced
		entre No	t Conce	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
	С	racks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct [		Weld
		rushed/0	Crimped.			Burrs		Instruct	ions Incomplete/I	Unclear		Part Lost/Mi	issing		Wrong Stock Pulled
	C	uffs				Contamination		Mainte	enance	Ī		Part Moved	•		-
	Пн	eat Trea	t			Countersink		Mislabe	eled			Positioned V	Vrong		
	Ir	spection	n Strip in	Tube		Cut Too Short	Г	Misread	d			Power Loss/	Surge		Other
	∏ <sub>R</sub>	ipples in	Bend			Drill Holes		Offset		•		•			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Orde		630		*916	330*						Page 2
Revision ID:	D3929-041 Gusset Assemi	bly		Accept	*N900	<b>040</b>	100	)* 5	Setup Sta	1.7	S1* S2*
	10/18/12 11/02/12	Start Qty: 4.00 Req'd Qty: 4.00		4* 4*	Cust Item I Customer:	D:					
Approvals:		in:				ate:		1	Run Sta Sto		R1* R2*
Sequence ID/ Work Center II 120 *170* QC Quality Control	)	Operation Description QC8- Inspect parts - second	ond check	Set Up/ Run Hours 0.00 Sml		Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*140 *140* Large Fab Large Fab			ngs D3907-1 as batch: _M / &	_			(2	(y)	12/1	<u> </u>	MAL
150 *150* QC		QC9- Inspect visual per	QSI004- Fusion	Welds 0.00 0.00				0	12-12	પ્ર-ગ્ર/	09

Quality Control

												DQA:	Dat	e:	
NCR: Y	es ,	/ No				WORK ORDER NON-	CO	<b>VFORN</b>	ANCE / UPI	DATE		·			
		***							-			QA Closed:	Dat	e:	
Work Orde	or:					DISPOSITION				AGAINST (	DEI	PARTMENT	PROCESS		
WOIK OIGE	:1. —					Rework	1		Skid-tube	Crosstube	٦	<b>1</b>	Water Jet		Engineering
Part N	No.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.		Quality
						Use-as-is		Therm	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	No					Work Order Update	]		Large Fab	Composite			Supplier		
Root					Descri	ption of work order update		Initial	Act	tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	$\Box$	QC Inspector
Doc/Data					,							ì			
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Operator					į										
Material					1										
Setup					r <sup>-</sup>										
Other															
Process															
Supplier															
Training															
Unapproved				<u> </u>			<u> </u>								
							AUI	LT CATE	GORY						
Landi						General		٦.٠.		Г		<b>1</b>			1
;	—	Bending				Bend	<u> </u>	Grain				Ovalized			Pressure/Forced
	$\boldsymbol{\vdash}$	Centre No	ot Conce	ntric to	o/s	BOM/Route	<u> </u>	Hardwa				Over/Under		_	Temperature/Cure
	$\vdash$	Cracks				Broken/Damaged	<u> </u>	-1	on Incomplete			Part Incorre		_	Weld
		Crushed/0	Crimped.			Burrs	_	4	ions Incomplete/	Unclear		Part Lost/M	issing	<u> </u>	Wrong Stock Pulled
	$\vdash$	Cuffs			<u> </u>	Contamination	<u></u>	Mainte				Part Moved			
	$\vdash$	leat Trea			·	Countersink	<u> </u>	Mislabe				Positioned \	-		3
	<del></del>	nspection		Tube	<u></u>	Cut Too Short		Misread	d ,			Power Loss/	Surge	L	Other
	F	Ripples in	Bend		1	Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Order ID 91630 \*91630\* Page 3 October-18-12 9:07:53 AM Item ID: D3929-041 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Gusset Assembly 10/18/12 Start Qty: 4.00 **Start Date: Cust Item ID: Req'd Qty:** 4.00 Required Date: 11/02/12 **Customer:** Reference: Run Process Plan: Date: **Tooling: Approvals:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Reject Reject Set Up/ Accept Insp. **Work Center ID** Qty **Description** Code **Qty** Number Stamp Run Hours OAS, 160 QC5- Inspect part completeness to step on W/O 0.00 \*160\* OC 0.00 Memo Quality Control Identify as per dwg & Stock Location: WAGT 170 12-12-21 MAL \*170\* 0.00 Packaging Memo Packaging 13/1/1040 MF-127 QC21- Final Inspection - Work Order Release 0.00 180 \*180\* QC 0.00 Memo Quality Control

												DQA:	Date	e:	
NCR: Y	es/	/ No				WORK ORDER NON-C	O	NFORN	IANCE / UPI	DATE		-	<del></del>	-	
								,			QA C	losed:	Dat	e:	
Work Orde						DISPOSITION				AGAINST DE	PART	MENT/	PROCESS		
WOIK OIGE	-					Rework	1	Skid-tube Crosstube			]		Water Jet	$\neg$	Engineering
Part N	No.					Scrap			//achining	Small Fab	Prod. Eng. Coor.				Quality
	_					Use-as-is			oforming	Finishing	R	ec/Stor	e/Packaging	$\perp$	Other
NCR N	۱o					Work Order Update			Large Fab	Composite	_		Supplier		
Root	T				Descri	ption of work order update	1	nitial	Act	tion	Sig	gn &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desci	ription	D	ate	Verification	1	QC Inspector
Doc/Data												ļ			
Equip/Tooling															
Operator															
Material							l								
Setup					,						1				
Other	$\Box$													- 1	
Process	Ц														
Supplier	Ш											i	:		
Training	Ц														
Unapproved		· · · · · · · · · · · · · · · · · · ·					<u> </u>	٠							
						<del></del>	AUL	T CATE	GORY						
Landi						General		1		<b>-</b>	٦.		1	_	1_ /
	-	Bending			_	Bend	ļ	Grain		<u> </u>	Oval			<u> </u>	Pressure/Forced
	Н	Centre No	ot Conce	ntric to	O/S	BOM/Route	-	Hardwa		<u> </u>	-1		tolerance	$\vdash$	Temperature/Cure
	Cracks					Broken/Damaged	<u> </u>	4 `	on Incomplete			Incorre		<u> </u>	Weld
	—	Crushed/0	Crimped		_	Burrs	<b>—</b>	4	ions Incomplete/	Unclear	⊣	Lost/Mi	ssing		Wrong Stock Pulled
	$\vdash$	Cuffs			-	Contamination	<u></u>	Mainte		<u> </u>	⊣	Moved			•
	$\boldsymbol{\vdash}$	Heat Trea			_	Countersink	_	Mislabe		<u> </u>	⊣ .	tioned V	· ·	_	<b>1.</b> .
	-	Inspection		Tube	<u> </u>	Cut Too Short		Misread	I		Pow	er Loss/	Surge	_	Other
		Ripples in	Bend		1	Drill Holes	1	Offset							

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

**Picklist Print** 

October-18-12 9:07:53 AM

Work Order ID:

91630

Parent Item:

D3929-041

Parent Item Name:

Gusset Assembly

**Start Date:** 10/18/12

Required Date: 11/02/12

Page 1

Start Qty: 4.00

Required Qty: 4.00

**Comments:** 

Component Item ID/	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	~ .	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	175.3500	0.45	1.8947368	<u>,                                      </u>		Jmr-10-19
				Location		Loc Qty	<u>L</u>	oc Code					
				MAT020		175.35							
				122	2521	175.35			12	2521			
D3907-1		Manufactured	No			130	Each	37.0000	2	8			
Bushing													
				Location		Loc Qty	<u>L</u>	oc Code					
				WA		37							
				888	391	1					/		
				(896	.88 × X = 8	36			=	8) - 1	2/12/	Q1 =	MAL

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	ON	NFORM	MANCE / UPD	ATE	·	<del></del>	
											QA Closed:	Date:	va:
Maril Ord						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Ord	er: _					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part f	No					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
10111	•••		<u> </u>			Use-as-is			noforming	Finishing		re/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite		Supplier	
Root					1	ption of work order update	l	nitial	Actio		Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data												i	
Equip/Tooling	Ш												
Operator	Щ												
Material	Ш												
Setup	$\vdash$										:		
Other	Н												
Process	Н					·							
Supplier	Н												
Training Unapproved	Н												
Onapproved	1L		L		1	F	AUL	T CATE	GORY			<u> </u>	
Landi	ing G	ear	. <u>.</u>	<del></del>		General							
		Bending				Bend		Grain			Ovalized		Pressure/Forced
Centre Not Concentric to O/S				BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure		
Cracks			Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld			
Crushed/Crimped.			Burrs		Instruct	tions Incomplete/U	nclear	Part Lost/M	issing	Wrong Stock Pulled			
	Cuffs					Contamination		Maintenance			Part Moved		
	[]	Heat Trea	it			Countersink		Mislabe	eled		Positioned \	<b>V</b> rong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	91430
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929 Rev: A		Page 1 of 1

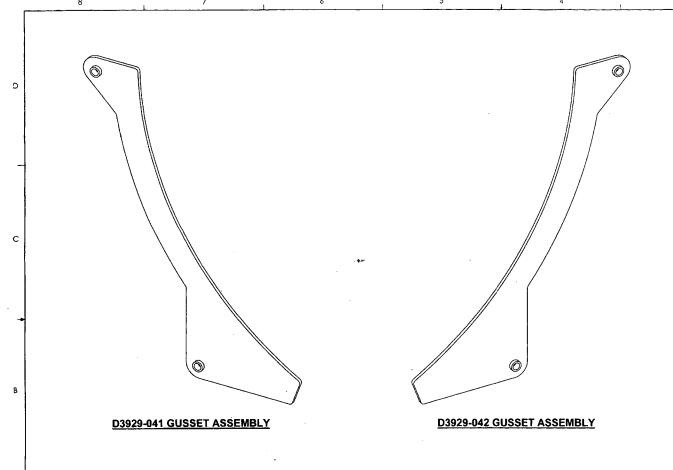
## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+0.006/-0.001	0.377	_		ļ	mer
0.500	+/-0.010	0.377 0.498"			U	ramo!
0.500	+/-0.010	0,501	<u> </u>		J	
4.036	+/-0.010	4.036			V	-
4.382	+/-0.010	4.382"	•		Ŭ	
8.274	+/-0.010	2 274	-		v	Produsoz
10.915	+/-0.010	10.916"			V	
1.000	+/-0.010	1.007	)		U	
11.198	+/-0.010	11,201	-		V	
0.500	+/-0.010	0.\$98	~		V	
1.572	+/-0.010	1.575"	-		V	
0.125	+/-0.010	A.117"	_		V	

Measured by:	Jm.	Audited by:	5mB	Prototype Approval:	N/A
Date:	12-10-19	Date:	1210-19	Date:	N/A

F	₹ev	Date	Change		Revise	T /	þу	/		roved
	Α	09.05.27	New Issue	P/O D3929-041/-042	KJ d	Z	t		N	
						7	$T^{-}$		- T-	



QTY -041 Q1Y -042 ITEM P/N DESCRIPTION GUSSET ASSEMBLY
GUSSET ASSEMBLY D3929-041 D3929-042 2 D3907-1 1 D3929-1 BUSHING SUPPORT GUSSET 12

3

91630 \$12-10-16

A	NEWIS	SUE		мв	09.04.03		
REV.		.,	DESCRIPTION	BY	DATE		
DESIG	N	1	DART AEROSPA	CE L	[D		
DRAW	N	کے	HAWKESBURY, ONTARIO				
CHECK	ŒĎ	P&K	DRAWING NO.		REV. A		
MFG. A	PPR.	M.	D3929		SHEET 1 OF 3		
APPRO	OVED	1 de	TITLE		SCALE		
DE API	PR.	4	GUSSET ASSEMBLY		NTS		
DATE	09.0	4.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS FRIMATE AND COMPOSITION AND IS SUPPLIED AND EDIFFECTS CONDITION THAT IT IS NOT TO BE LISED FOR ANY PROPECTS OF COMPANION TO TO ANY OTHER PURSON WITHOUT				

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 lbs EACH
8) WELDING: PER DART QSI 004

